



Dart Aerospace Ltd.
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D5468-1**Job Sheet 191275****Part No:** D5468-1**Job Qty:** 2 pcs**Part Name:** Saddle, Aft, Out**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/26/19**Job Tracking No:****Due Date:** 3/8/19**Created By:** Jason Leroux**Type:** Stock**Description:****Note:** IPP Rev.A 17.07.12 New issue DP Verify DD IPP REV:B 17.11.03 AS PER DWG REV.A DD VERF:DP**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	2 pcs	3/8/19		0.00	3.96	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 19/02/27
							HAAS - 4		
120	QC 2	2 pcs	3/8/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		SBL 19/02/27
							QC 2 - 62		

**Container No:** S156887**Part:** D5468-1**Job No:** 191275**Serial No/Batch:** S156887**Revision:** A**Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 02/27/19

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130	QC 8	2 pcs	3/8/19	0.00 0.00	QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
140	Handfinish - 1-1 Chemical-B4B	2 pcs	3/8/19	0.00 0.28	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Spray Paint - 2 - B4B	2 pcs	3/8/19	0.00 0.05	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
160	QC 14	2 pcs	3/8/19	0.00 0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	

				QC 14 - 9	
				QC 14 - 68	
163 Outsource - 11 - Paint	2 pcs	3/8/19		ATE003-VC	2
165 Packaging 2-1 - Receive - B4B	2 pcs	3/8/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
167 QC 6	2 pcs	3/8/19	0.00 0.00	QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
170 Packaging 3-1 - Stock - B4B	2 pcs	3/8/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	

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				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
180 QC 21 - SA	2 pcs	3/8/19	0.00 0.00		

Part Op 100 - (HAAS CNC Vertical Machine) Program Batch No. _____ Double check by: _____ 1-Machine Step No 1 per
 Descriptions: Folio FB548 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FB548 and inspect per attached
 Dimension Sheets 3-Machine Step No 3 per Folio FB548 and insp
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (Spray Paint / NDT Room) ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 9*** 1-PRIME AS
 PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4
 PAINT BATCH: _____
 160 - (QC14- Inspect Spray Paint)
 163 - ISSUE P/O: _____ ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-
 PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND
 QSI005 4.2.2.4 PAINT BATCH: _____ C OF C IS REQUIRED
 165 - (Receive & Inspect for Damage & Mat'l Certs)
 167 - (QC6- All purchased or subcontracted products)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	2 pcs (1 ea)	100-HAAS 4 Axis	5147787

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-007	2	13	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 191275
Description: SADDLE AFT OUT		Part Number: 191275 D5468-1
Inspection Dwg: D5468-1	Rev: A	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.438	0.443		.438	.438			
B	1.745	1.755		1.750	1.750			
C	3.505	3.505		3.500	3.500			
D	1.745	1.755		1.750	1.750			
E	7.990	8.010		8.000	8.000			
F	0.490	0.510		.502	.500			
G	0.257	0.262	0.257	.257	.257			
H	0.375	0.380	0.375	.378	.378			
I	0.490	0.510	0.501	.501	.502			
J	1.174	1.184	1.174	1.179	1.179			
K	0.558	0.578		.570	.570			
L	1.174	1.184	1.174	1.179	1.179			
M	1.365	1.375	1.370	1.370	1.370			
N	2.495	2.505	2.500	2.500	2.500			
O	4.119	4.129	4.124	4.124	4.124			
P	0.115	0.135		.127	.127			
Q	0.115	0.135	0.125	.125	.126			
R	0.240	0.260	0.252	.252	.253			
S	0.115	0.135		.130	.130			
T	0.178	0.188		.188	.188			
U	3.210	3.250	3.230	3.230	3.230			
V	0.230	0.250		.238	.239			
W	0.115	0.135		.133	.133			
AI	2.000	2.020		2.003	2.003			
Z	0.352	0.372		.365	.364			
AA	0.470	0.530		.500	.500			
AB	0.615	0.635		.620	.625			
AC	0.065	0.073		.066	.062			
AD	0.240	0.260		.249	.249			
AE	1.500	1.520		1.515	1.515			
AF	0.115	0.135		.127	.125			
AG	0.240	0.280		.250	.250			
AH	0.240	0.260		.250	.250			

DAS Accept/Reject

Measured by: 57	Date: 2019/02/27
Audited by: 9-89	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	

DQA: _____ Date: 19/2/25

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>188001</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. <u>D5468-1</u>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Large Fab ☐	Composite ☐	Supplier ☐				

Date: 19/02/25 Step #: 100 QTY Effective: 2 MRB (QSI042) Approval PD 19-02-26

Description Work Order Deviation Due to power shortage, the milling machined down into the part while stopping.	Disposition scrap and destroyed.	Completed By <u>VH8</u>
		Lead hand / Supervisor Approval Verification <u>A 19-02-26</u>
		QC / QA Coordinator Approval <u>PD 19-02-26</u>

Root Cause				FAULT CATEGORY			
Environment ☒	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☒	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER: _____					
Misidentified ☐	Past Due ☐						